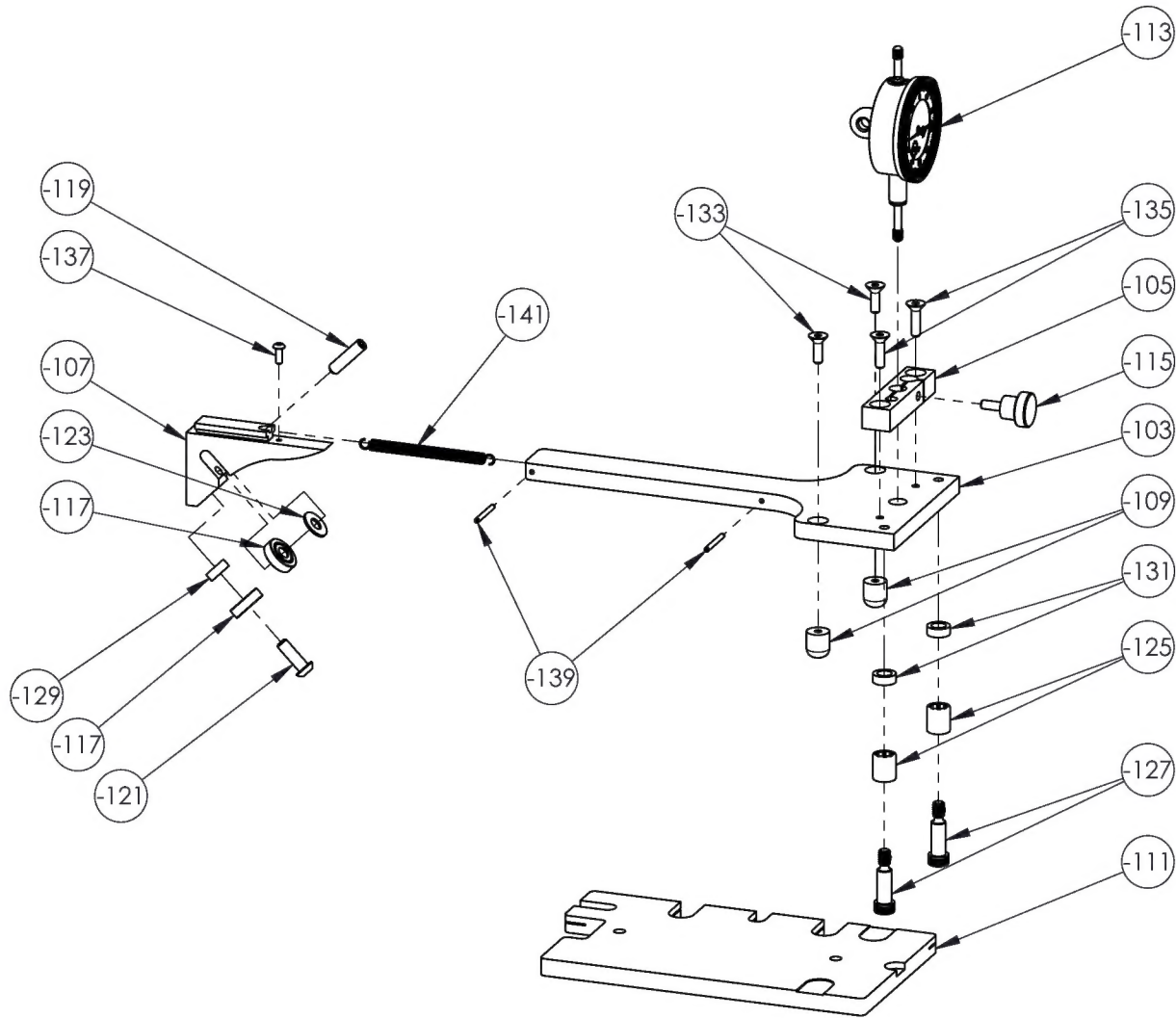
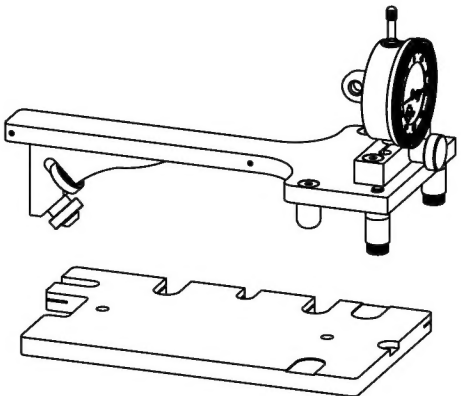


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		UPDATED TITLEBLOCK & REVISION BLOCK, UPDATED CONTACT INFO & ADDED PIN HOLES PG #1 & ENGRAVE NOTE ON BODY P/N -103.	6/2/2009	RJC	-
2		CH'D CUT WITH BAND SAW TO EDM P/N -105 PER G.E.	10/28/2009	RJC	GE
2A		ADDED ASSY. VIEW OF TOOL TO SHOW -111, ADDED TOOL INSTRUCTIONS.	2/11/2010	RJC	RW
3	16-0231	UPDATED TO NEW STANDARD. UPDATED USED ON MODELS. ADDED DASH NUMBERS TO B/O PARTS. -103 CH'D ENGRAVE NOTE WAS ENGRAVE P/N, S/N, "MADE IN USA" IS ENGRAVE T/N, S/N, "MADE IN USA". CH'D DIMS WAS .344 IS .34, WAS .350 IS 2X .350, WAS .665 IS 2X .665, WAS 1.850 IS 2X 1.850, WAS 2.38 IS 2X 2.38, WAS .500 IS 3X .50, WAS .28 IS (.28), WAS .375 IS .38, WAS 2X Ø.094 IS 2X Ø.094-.097 THRU ALL (P.F. -139). WAS .105 IS .105+.000-.005 (S.F. -107). WAS .300 IS .300+.010-.000 (S.F. -107). WAS 2.383 IS 2.38, DELETED DIMS .907, 2.70, ADDED DIMS .56, 2.55. ADDED FINISH SPEC MIL-A-8625F, TYPE II, CLASS II. -105 CH'D DIMS WAS .310 IS 4X .310, WAS .650 IS .65, WAS 2.750 IS 2.75. ADDED DIM .25. ADDED FINISH SPEC MIL-A-8625F, TYPE II, CLASS II. -107 CH'D MAT'L WAS NYLON OR DELRIN IS NYLON/DELIN/ACETAL. CH'D DIMS WAS .530 IS (.530), WAS 1.900 IS 1.90. WAS .135 IS 2X .130, WAS .105 IS 2X .110+.005-.000 (S.F. -103). ADDED DIMS .25, .25, .500+.000-.005 (S.F. -103). -109 CH'D MAT'L WAS NYLON OR DELRIN IS NYLON/DELIN/ACETAL. CH'D DIM WAS Ø.13 IS (Ø.13). -111 CH'D DIMS WAS 1.25 IS 2X 1.25, WAS .40 IS .39. -113 ADDED B/O REF (#76450071). -115 CH'D B/O REF WAS #KKT-1A OR #KKT-11A IS (#SKA-1). -117 CH'D B/O REF WAS #NNB-04 IS (#35437417). -119 ADDED B/O REF (#91375A542). -121 ADDED B/O REF (#91255A540). -123 ADDED B/O REF (#90107A029). -127 ADDED B/O REF (#91264A540). -129 CH'D QTY WAS 5 IS 1. CH'D B/O REF WAS #94639A138 IS (#94639A568). -131 ADDED TO BOM QTY 2, ADDED DRAWING. -133 ADDED B/O REF (#92210A244). -135 ADDED B/O REF (#92210A245). -137 ADDED B/O REF (#92949A146). -139 ADD B/O REF (#92373A149). -141 CH'D B/O REF WAS ES-0414 OR #80309S IS (#80309S).	11/23/2016	DPD	JAG



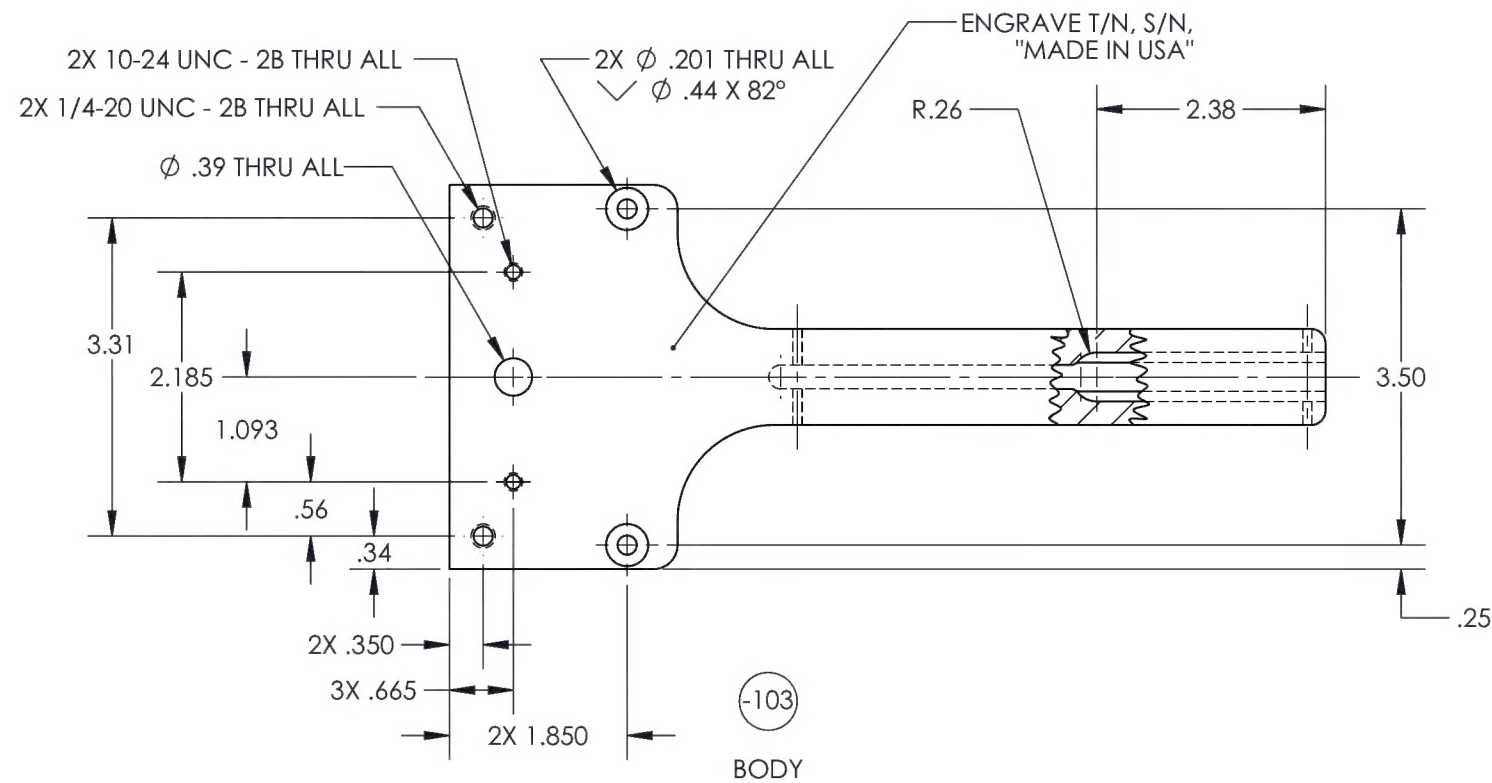
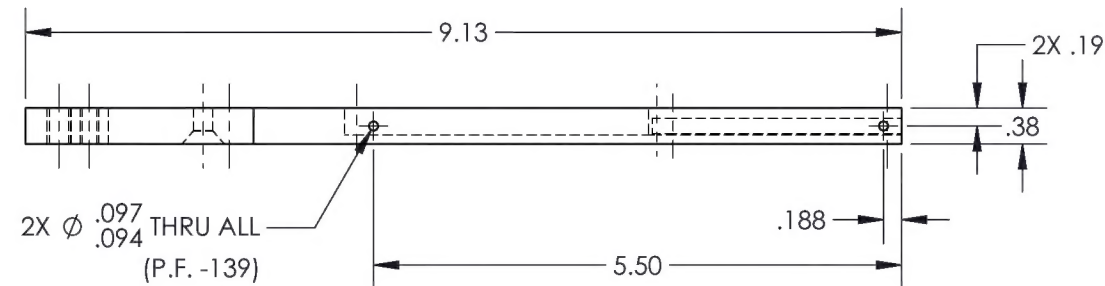
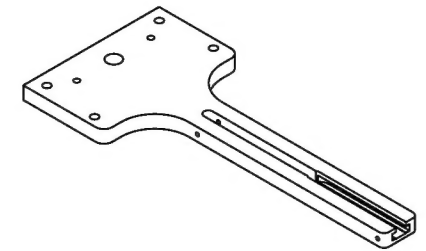
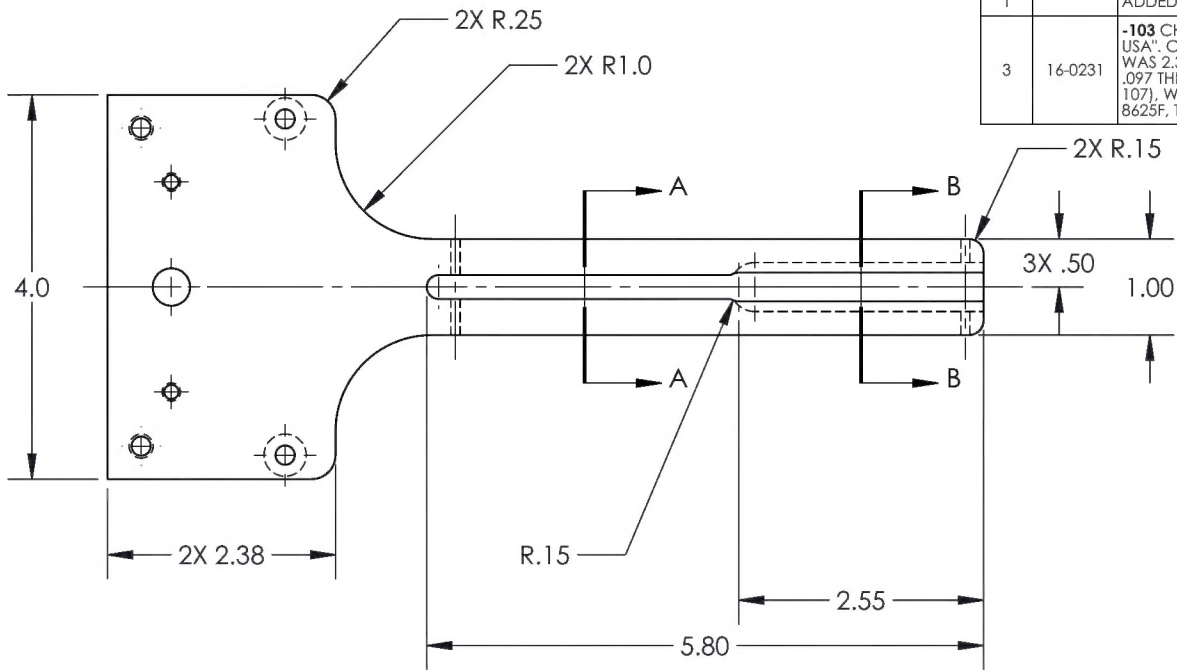
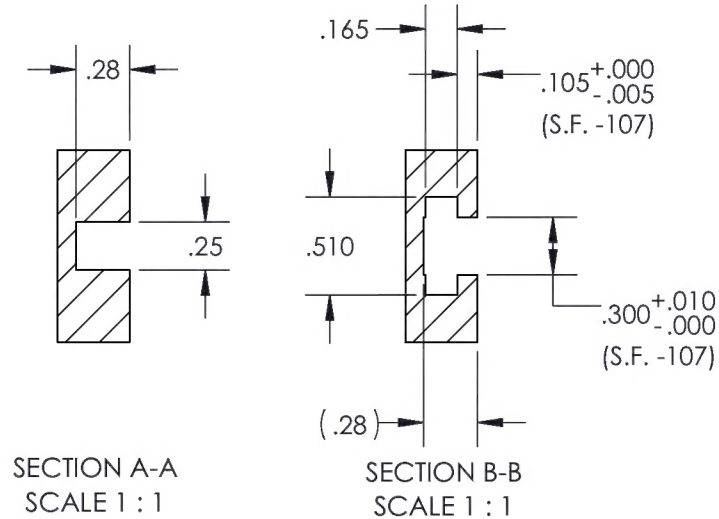
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-103	1	BODY	6061		2
			-105	1	BRIDGE	6061		3
			-107	1	HOOK	NYLON/DELIN/ACETAL		4
			-109	2	GLIDE	NYLON/DELIN/ACETAL		5
			-111	1	TAB BENDER	NYLON/DELIN/ACETAL		6
		B/O	-113	1	DIAL INDICATOR		Ø2-9/32, 1 in RANGE, 0-100 DIAL, .001 GRADUATION (MSC #76450071)	1
		B/O	-115	1	KNURLED KNOB	STEEL	10-24 X 1/2 (ESSENTA COMPONENTS #SKA-1)	1
		B/O	-117	2	ROLLER BEARING	PLASTIC	Ø3/4 O.D. X 7/32 (MSC #35437417)	1
		B/O	-119	1	SET SCREW	STEEL	1/4-20 X 1 (MCMASTER-CARR #91375A542)	1
		B/O	-121	1	SCREW	STEEL	1/4-20 X 3/4 (MCMASTER-CARR #91255A540)	1
		B/O	-123	1	WASHER	S.S.	Ø1/4 X .043-.057 THICK (MCMASTER-CARR #90107A029)	1
		B/O	-125	2	NEEDLE BEARING		Ø5/16 I.D. X Ø1/2 O.D. X 9/16 (MSC #09016452)	1
		B/O	-127	2	SHOULDER BOLT	STEEL	Ø5/16 X 3/4, 1/4-20 X 7/16 (MCMASTER-CARR #91264A540)	1
		B/O	-129	1	SPACER	NYLON	Ø1/2 O.D. X Ø1/4 I.D. X 3/16 (MCMASTER-CARR #94639A568)	1
			-131	2	MODIFIED SPACER	NYLON	Ø1/2 O.D. X Ø1/4 I.D. X 3/16 (MCMASTER-CARR #94639A568) MODIFIED	7
		B/O	-133	2	FLAT HEAD SCREW	S.S.	10-24 X 5/8 (MCMASTER-CARR #92210A244)	1
		B/O	-135	2	FLAT HEAD SCREW	S.S.	10-24 X 3/4 (MCMASTER-CARR #92210A245)	1
		B/O	-137	1	BUTTON HEAD CAP SCREW	S.S.	6-32 X 3/8 (MCMASTER-CARR #92949A146)	1
		B/O	-139	2	ROLL PIN	S.S.	Ø3/32 X 1 (MCMASTER-CARR #92373A149)	1
		B/O	-141	1	EXTENSION SPRING	S.S.	Ø.240 O.D. X Ø.031 WIRE X 2.25, 2 LBS/IN (CENTURY SPRING #80309S)	1

NOTE:
REFERENCE MD T/N: 369H9928-101.

DART AEROSPACE			
TITLE TAB TOOL			
DWG NO. RBH9928-101			REV 3
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
DRAWN BY:	PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:	MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	LINDSAY	USED ON MODEL	
APPROVED:	GILBERT	MD500, MD520, MD530	
SCALE	1:4	DATE	8/15/2007
		SHEET 1 OF 9	

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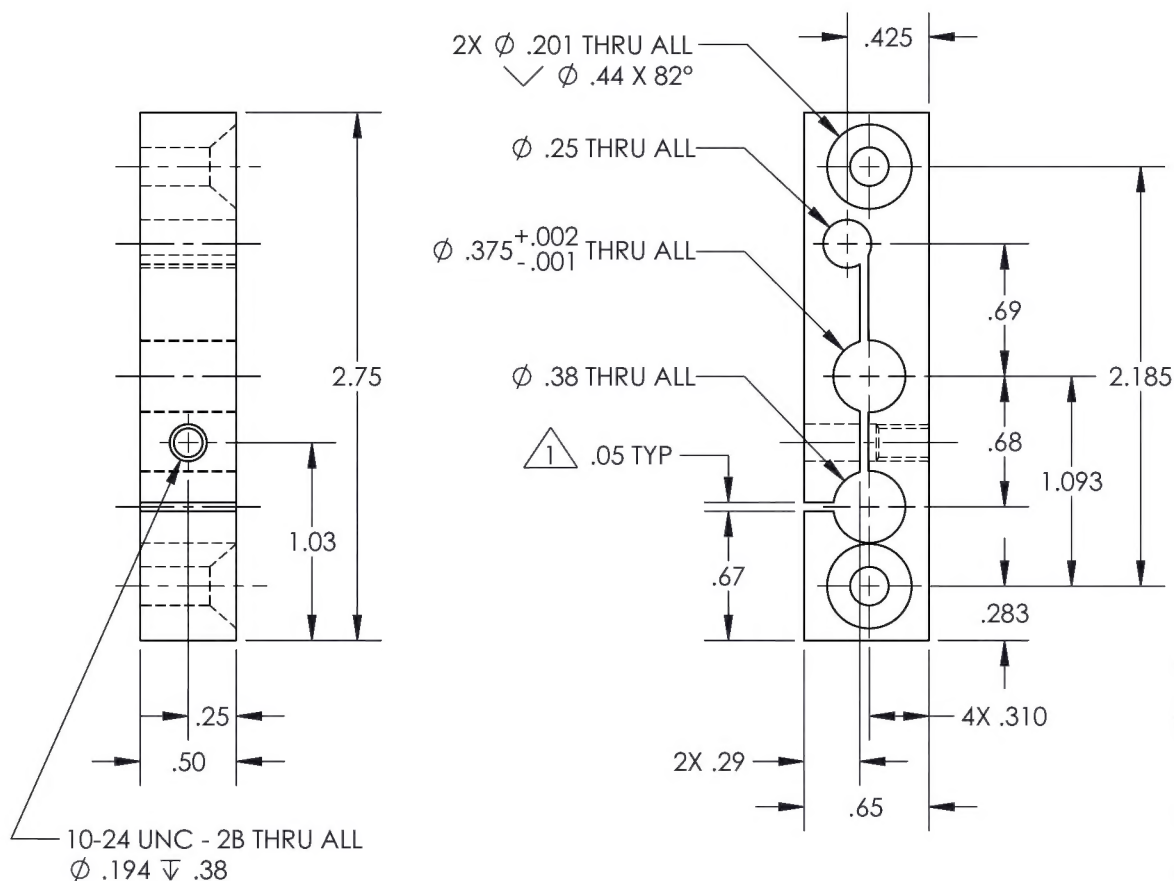
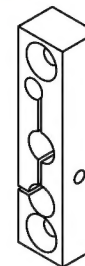
REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		ADDED PIN HOLES PG #1 & ENGRAVE NOTE ON BODY P/N -103.	6/2/2009	RJC	-
3	16-0231	-103 CH'D ENGRAVE NOTE WAS ENGRAVE P/N, S/N, "MADE IN USA" IS ENGRAVE T/N, S/N, "MADE IN USA". CH'D DIMS WAS .344 IS .34, WAS .350 IS 2X .350, WAS .665 IS 2X .665, WAS 1.850 IS 2X 1.850, WAS 2.38 IS 2X 2.38, WAS .500 IS 3X .50, WAS .28 IS (.28), WAS .375 IS .38, WAS 2X Ø.094 IS 2X Ø.094-.097 THRU ALL (P.F. -139), WAS .105 IS .105+.000-.005 (S.F. -107), WAS .300 IS .300+.010-.000 (S.F. -107), WAS 2.383 IS 2.38, DELETED DIMS .907, 2.70. ADDED DIMS .56, 2.55. ADDED FINISH SPEC MIL-A-8625F, TYPE II, CLASS II.	11/23/2016	DPD	JAG



DART AEROSPACE		
TITLE TAB TOOL		
DWG NO. RBH9928-101-103	REV 3	
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8	
FINISH RED ANODIZE	.XX ± .01 ANGLES ± 5°	
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/✓	
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY	USED ON MODEL	
APPROVED: GILBERT	MD500, MD520, MD530	
SCALE 1:2	DATE 8/15/2007	SHEET 2 OF 9

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D CUT WITH BAND SAW TO EDM P/N -105 PER G.E.	10/28/2009	RJC	
3	16-0231	-105 CH'D DIMS WAS .310 IS 4X .310, WAS .650 IS .65, WAS 2.750 IS 2.75. ADDED DIM .25. ADDED FINISH SPEC MIL-A-8625F, TYPE II, CLASS II.	11/23/2016	DPD	JAG



NOTE:

$\triangle 1$ SLOTS ARE EDM.

DART
AEROSPACE

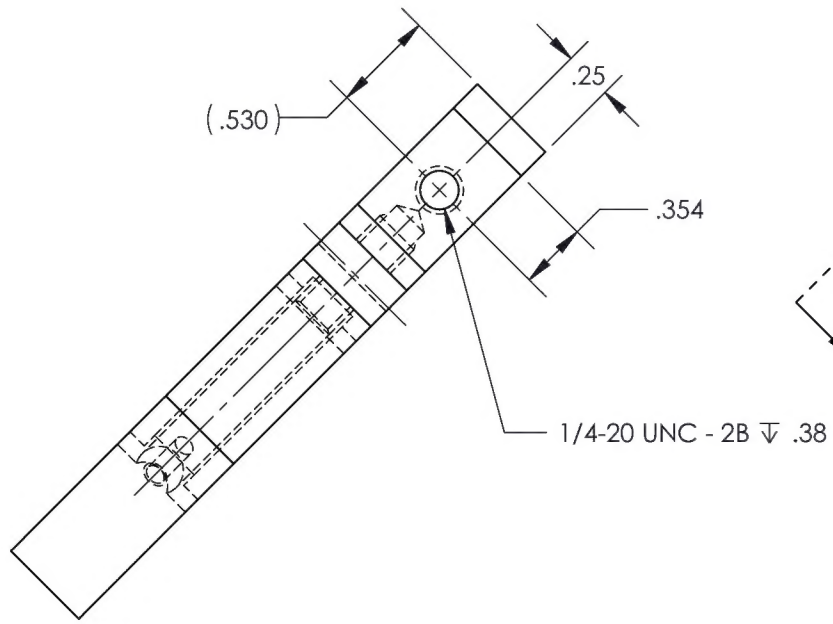
TITLE		TAB TOOL	
DWG NO.		RBH9928-101-105	
REV		3	
MAT'L 6061		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH RED ANODIZE		.XXX \pm .005 FRACTIONS \pm 1/8	
SPEC MIL-A-8625F, TYPE II, CLASS II		.XX \pm .01 ANGLES \pm .5°	
DRAWN BY: PERRITT		.X \pm .1 SURFACES = 125	
CHECKED: MACKOVJAK		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 8/15/2007		USED ON MODEL	
SHEET 3 OF 9		MD500, MD520, MD530	

(-105)

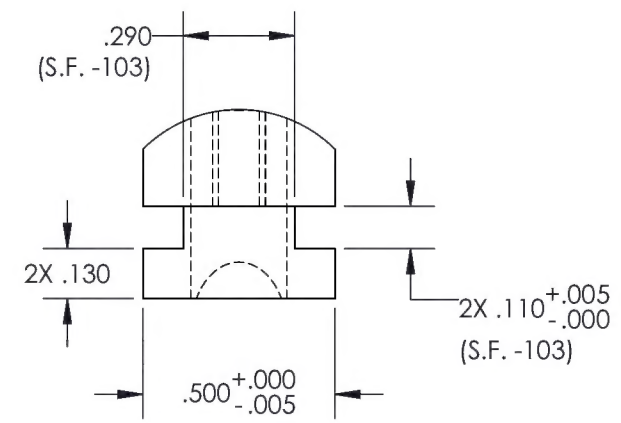
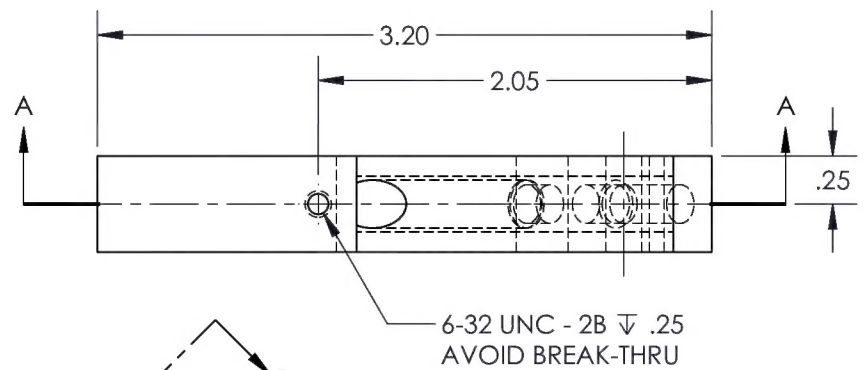
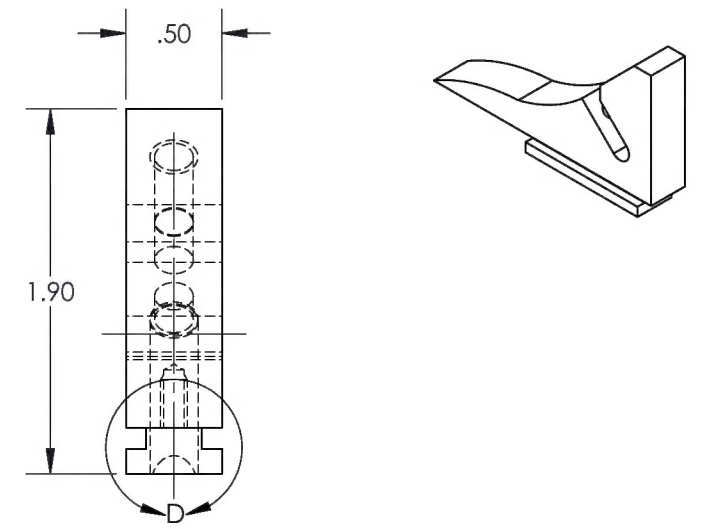
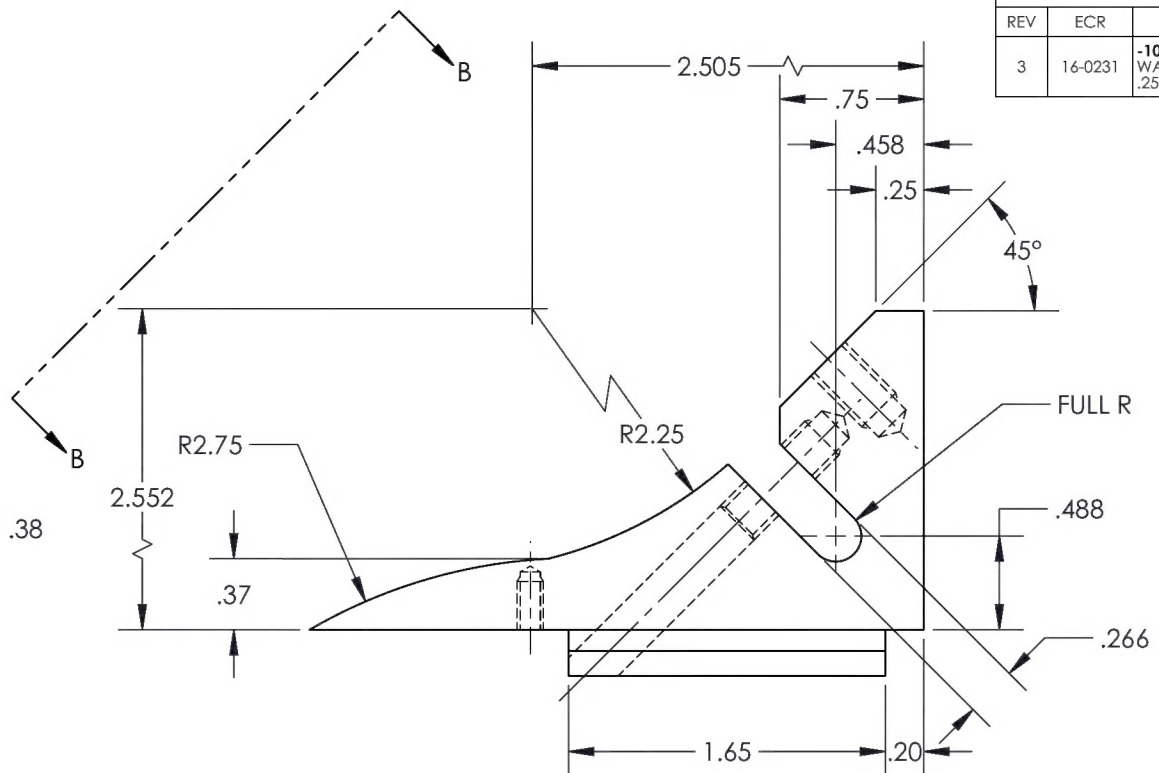
BRIDGE

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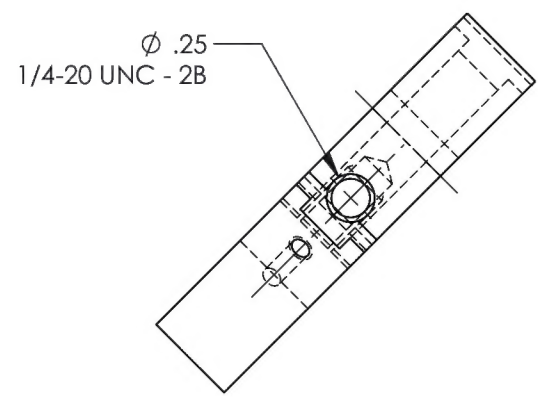
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0231	-107 CH'D MAT'L WAS NYLON OR DELRIN IS NYLON/DELRIN/ACETAL. CH'D DIMS WAS .530 IS (.530), WAS 1.900 IS 1.90, WAS .135 IS 2X .130, WAS .105 IS 2X .110 +.005-.000 (S.F. -103). ADDED DIMS .25, .25, .500 +.000 -.005 (S.F. -103).	11/23/2016	DPD	JAG



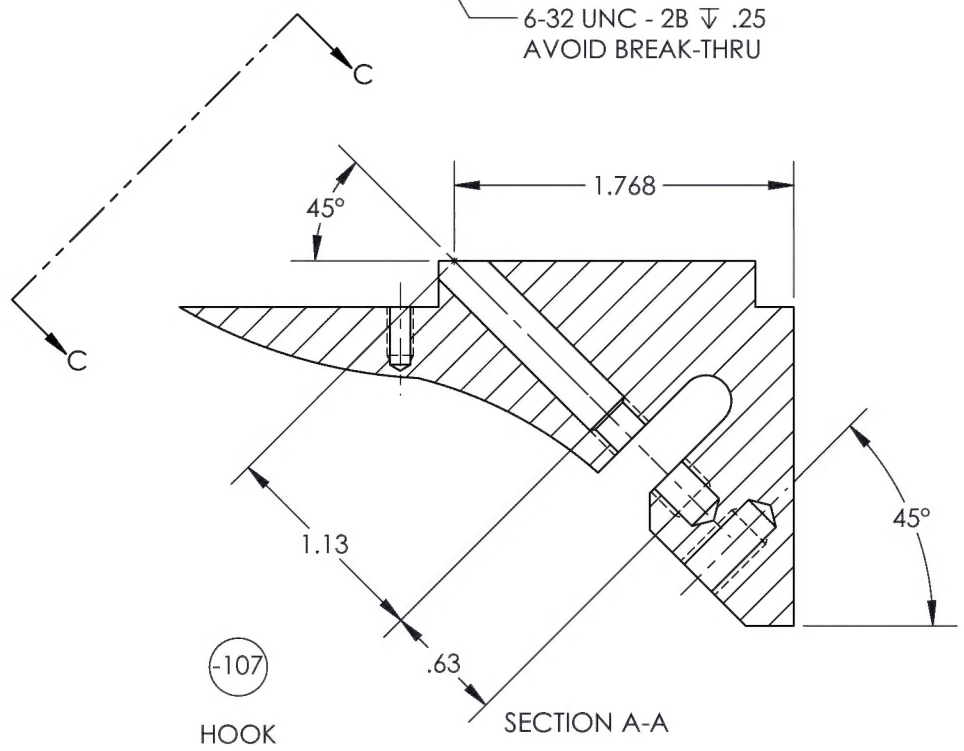
VIEW B-B



DETAIL D
SCALE 2 : 1



VIEW C-C



-107

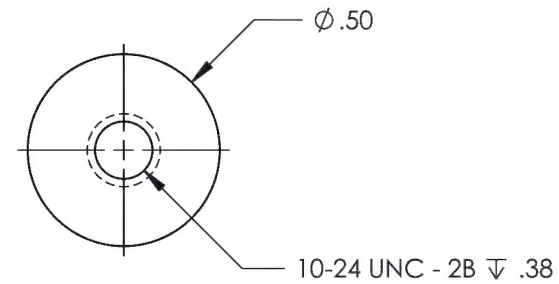
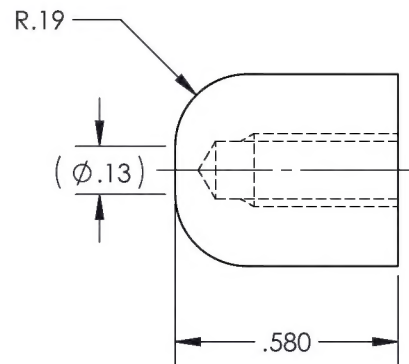
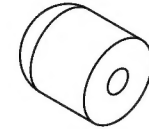
HOOK

SECTION A-A

DART AEROSPACE			
TITLE TAB TOOL			
DWG NO. RBH9928-101-107			REV 3
MAT'L NYLON/DELIN/ACETAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH		.XX ± .01 ANGLES ± 5°	
SPEC		.X ± .1 SURFACES = 125	
DRAWN BY: PERRITT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		MD500, MD520, MD530	
SCALE 1:1	DATE 8/15/2007	SHEET 4 OF 9	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0231	-109 CH'D MAT'L WAS NYLON OR DELRIN IS NYLON/DELRIN/ACETAL. CH'D DIM WAS Ø.13 IS (Ø.13).	11/23/2016	DPD	JAG

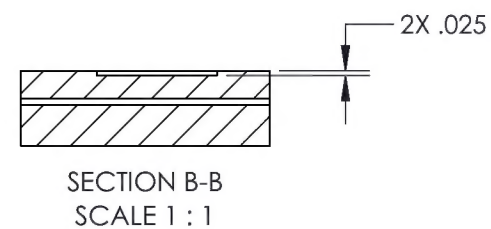



(-109)

GLIDE

DART AEROSPACE	
TITLE TAB TOOL	
DWG NO. RBH9928-101-109	REV 3
MAT'L NYLON/DELRIN/ACETAL	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 2:1	DATE 8/15/2007
	SHEET 5 OF 9

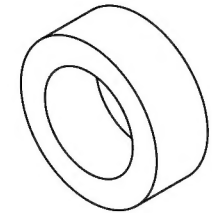
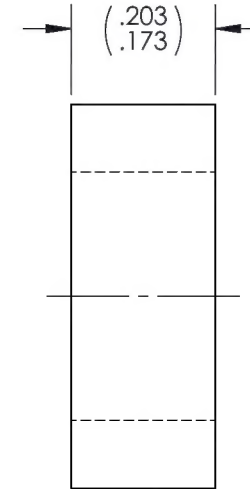
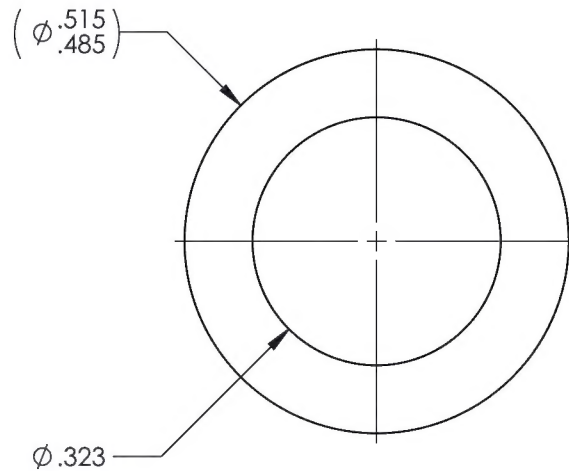
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0231	•111 CH'D DIMS WAS 1.25 IS 2X 1.25, WAS .40 IS .39.	11/23/2016	DPD	JAG



			
TITLE			
TAB TOOL			
DWG NO.			REV
RBH9928-101-111			3
MAT'L NYLON/DELTRIN/ACETAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ±.5°	
		.X ± .1 SURFACES = 125/√	
DRAWN BY: PERRITT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER FLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		MD500, MD520, MD530	
SCALE	1:2	DATE	8/15/2007
		SHEET 6 OF 9	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0231	-131 ADDED DRAWING.	11/23/2016	DPD	JAG



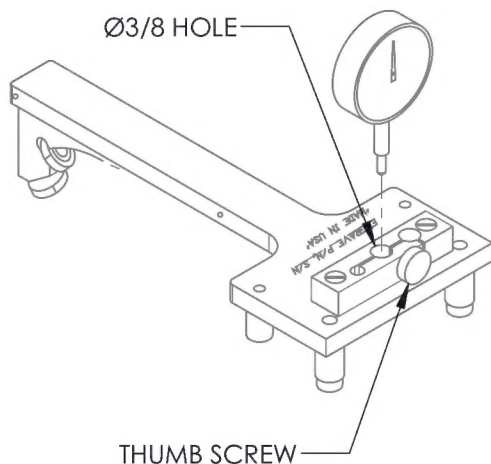
(-131)

MODIFIED SPACER

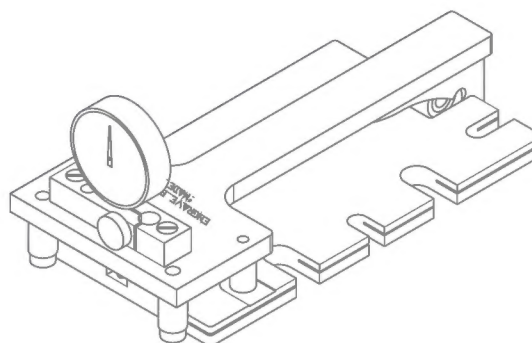
DART AEROSPACE	
TITLE TAB TOOL	
DWG NO. RBH9928-101-131	REV 3
MAT'L NYLON	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	MD500, MD520, MD530
SCALE 4:1	DATE 8/15/2007
	SHEET 7 OF 9

MD-500 TAB TOOL INSTRUCTIONS

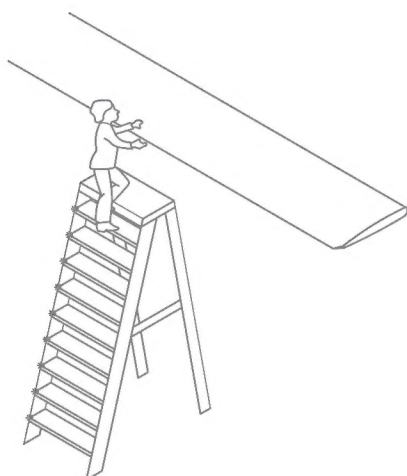
1. Insert dial indicator into 3/8 hole in tab tool part # RBH9928-101. Seat it all the way down and tighten thumb screw.



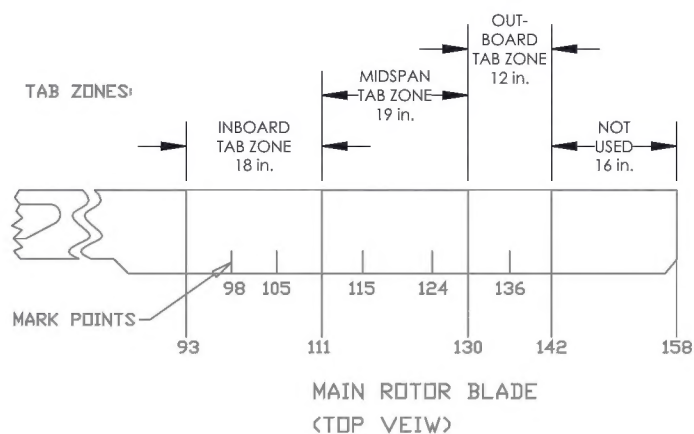
2. Place tab bender part # RBH9928-111 on the under side of tab tool part # RBH9928-101 so that the pointer of the dial indicator rests on the calibration step and the guide pins hang over the edge as shown.



3. Stand on a sturdy ladder at the trailing edge of the rotor blade, near the tabs.



4. Mark tabs as shown below.

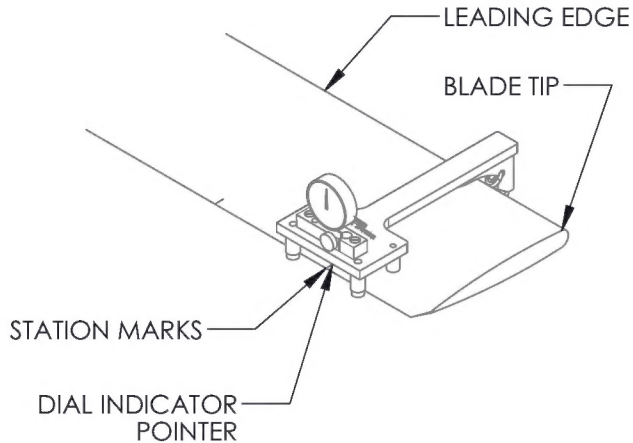


190 S. Danebo Ave., Eugene, OR. 97402
1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

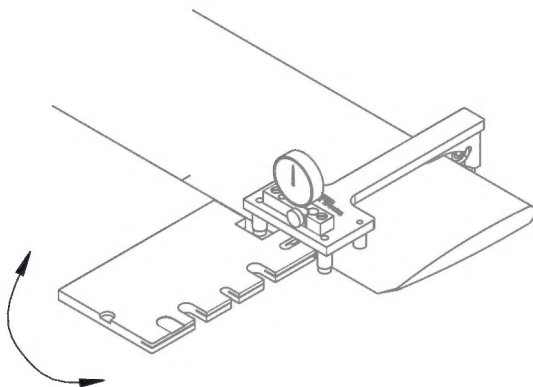
TITLE			TAB TOOL	
DWG NO.	RBH9928-101	REV	3	CUSTOMER 1 OF 2
SCALE	DATE	8/15/2007	SHEET	8 OF 9

MD-500 TAB TOOL INSTRUCTIONS

5. Place tab tool on blade as follows:
Hook leading-edge rollers of tab tool over the leading edge of the blade. Pull the large end (with dial indicator) aft and hook the guide pins over the trailing edge of blade tab, with the pointer of the dial indicator on the upper surface of tab.



NOTE: Prior to, or during track and balancing, the small end of the tab bender may be used to bend small tab sections to straighten waviness in the tab.



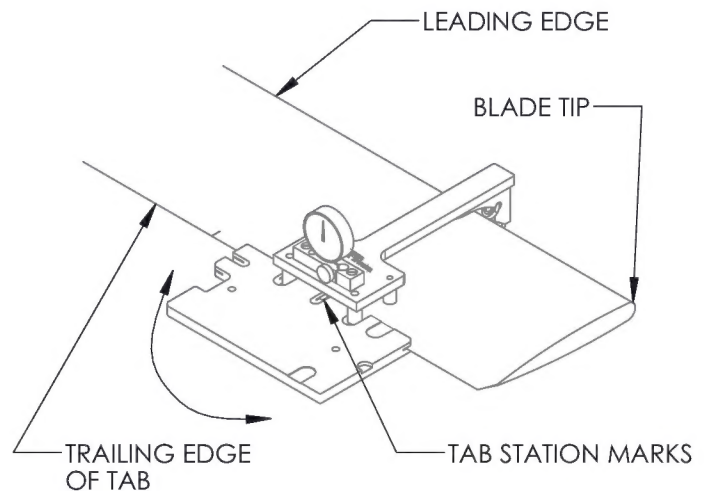
6. Slide the pointer of the dial indicator to each of the 5 marks and record the setting at each station (average the two readings for the inner and middle tab zones). Use an arrow to indicate whether the tab is up or down.

	TAB MEASUREMENT STATIONS						
	INBOARD			MIDSPAN			OUTBOARD
	98"	105"	AVG.	115"	124"	AVG.	136"
BLADE 1							
BLADE 2							
BLADE 3							
BLADE 4							
BLADE 5							

1 MIL = .001"

INDICATE  OR 

7. Place tab bender on tab and bend tab the prescribed amount (up or down) at each corresponding mark.



DART
AEROSPACE

190 S. Danebo Ave., Eugene, OR. 97402

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dartaerospace.com

TITLE			
TAB TOOL			
DWG NO.	RBH9928-101	REV	CUSTOMER 2 OF 2
SCALE	DATE	8/15/2007	SHEET 9 OF 9